



Dart Aerospace Ltd.
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D2896-1

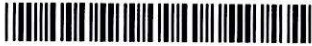
Job Sheet 214236



Part No: D2896-1

Job Qty: 4 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/21/20

Job Tracking No:

Due Date: 11/16/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 02.11.26 Reformat; Added P/O; Added mask hole KJ IPP Rev:C As per Rev B 07-04-16
JLM IPP D 08.03.19 Re-format EC verified by DD IPP REV:E 11.10.03 ASPER REV:C DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs		11/16/20	0.32	13.25	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	4 pcs		11/16/20	0.00	0.00	QC 8 - 12		SL 20-11-11
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		SL 20-11-15
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		

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Container No: S312069

Part: D2896-1

Job No: 214236

Serial No/Batch: S312069

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/10/20

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				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
130 Packaging 3-1 - Stock - B4B 4 pcs	11/16/20	0.00	0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	DAS
				Packaging 3 - 22 - B4B	41 NOV 15 2020
				Packaging 3 - 23 - B4B	9-89
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
140 QC 21 - SA 4 pcs	11/16/20	0.00	0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89
				QC 21 - SA - 9	
				QC 21 - SA - 77	NOV 16 2020
				QC 21 - SA - 28	
Part Op 100 - (HAAS CNC Vertical Machine) Machine as per Folio FA167 Folio Rev: PA Deburr ****Program Batch					
Descriptions: #*****					
120 - (QC8- Inspect parts - second check)					
130 - (Identify as per dwg & Stock Location:) LOCATION : LC053 LG051					
140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
DSK080	D2896-1 Turning Detail	2 pcs (.5 ea)	100-HAAS 4 Axis	5169.569 X1	
				5265862 X1	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	DSK080	2	7	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	2.152Inches + 0.020 - 0.000	2.172 2.152		
2	Support	2.340Inches + 0.020 - 0.000	2.360 2.340		
3	Support	3.550Inches + 0.010 - 0.000	3.560 3.550		
4	Support	3.770Inches + 0.020 - 0.000	3.790 3.770		
5	Support	0.065Inches + 0.020 - 0.000	0.085 0.065		
6	Support	0.315Inches + 0.020 - 0.000	0.335 0.315		
7	Support	1.420Inches + 0.060 - 0.000	1.480 1.420		
8	Support	0.833Inches + 0.020 - 0.000	0.853 0.833		
9	Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
10	Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
11	Support	0.189Inches + 0.005 - 0.000	0.194 0.189		
12	Support	1.970Inches + 0.060 - 0.000	2.030 1.970		
13	Support	0.625Inches + 0.005 - 0.000	0.630 0.625		
14	Support	101.750Inches + 4.000 - 0.000	105.750 101.750		
15	Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
16	Support	0.926Inches + 0.020 - 0.000	0.946 0.926		

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DART AEROSPACE LTD		Work Order: 214236
Description: Support		Part Number: D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.152	2.172		2.164	2.166	2.166	2.165	
AB	2.340	2.360		2.351	2.350	2.353	2.353	
AC	3.550	3.560		3.553	3.553	3.554	3.555	
AD	3.770	3.790		3.775	3.774	3.773	3.773	
AE	0.065 x 0.315	0.085 x 0.335		3.20X.075	3.20X.075	3.20X.075	3.20X.075	
AF	1.42	1.48		1.445	1.449	1.451	1.452	
AG	0.833	0.853		.841	.840	.841	.840	
AH	0.240	0.260		.250	.250	.250	.250	
AI	0.261	0.266		.261	.261	.261	.261	
AJ	0.189	0.194		.189	.189	.189	.189	
AK	1.970	2.030		2.004	2.003	2.001	2.001	
AL	0.625	0.630		.626	.626	.626	.626	
AM	101.75	105.75		103.75	103.75	103.75	103.75	
AN	0.053	0.073		.063	.063	.063	.063	
AO	0.926	0.946		.936	.937	.938	.937	
AP								
AQ								
AR								

Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"

Accept/Reject .001 .002 .005 .001

Measured by: JL	Date: 20-11-11
Audited by: DAS 20 9-89	Date: 20-11-15
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					